

Work Order ID 54807

December 22, 2009 1:25:42 PM

Page 1

Item ID: D3703-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Aft Doubler

Start Date: 1/05/10

Start Qty: 6.00

Cust Item ID:

Required Date: 1/15/10

Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan: CL

Date: 09/12/23 Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3703

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3703 (1 Dwg Rev: A (1 Prog Rev: A

1)

****grain direction along 6.30**** (12- Deburr if necessary

6061 . 063

NOT PULLED

FB 10-1-7

7

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

FB 10-1-7

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

⇒ S1010102

77

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3703-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Doubler

Start Date: 1/05/10 Start Qty: 6.00



Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC	NC BRAKE	0.00							
Brake NC	Memo Bend as per Dwg D3703	0.00	SB 12/02/02			7			
140 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00	S 12/03/02			(X7)			
150 HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00							
Hand Finishing	Memo	0.00	BR 10-3-3			(7)			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Item ID: D3703-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Doubler

Start Date: 1/05/10 Start Qty: 6.00



Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 83

0.00



Packaging

Memo

0.00

Packaging

10-3-3 (7050)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/05

MF

10-3-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 54807



Parent Item: D3703-1



Parent Item Name: Aft Doubler

Start Date: 1/05/10

Required Date: 1/15/10

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No				sf	55.7377	4.3200	S,		



6061-T6 .063 Sheet



12-1-7

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

55.73772105

110551

29.6341211

112939

26.1036

112939

7

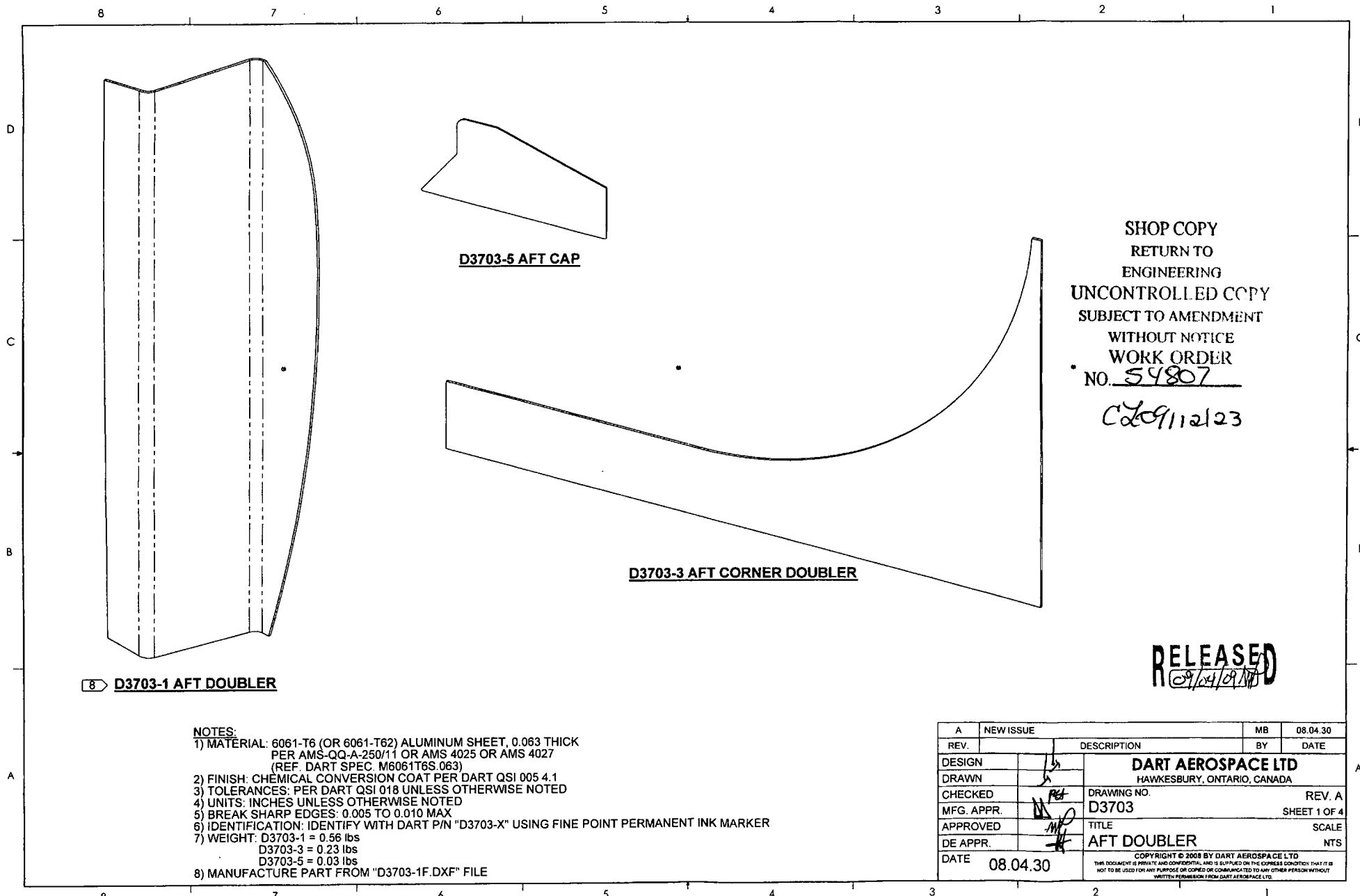
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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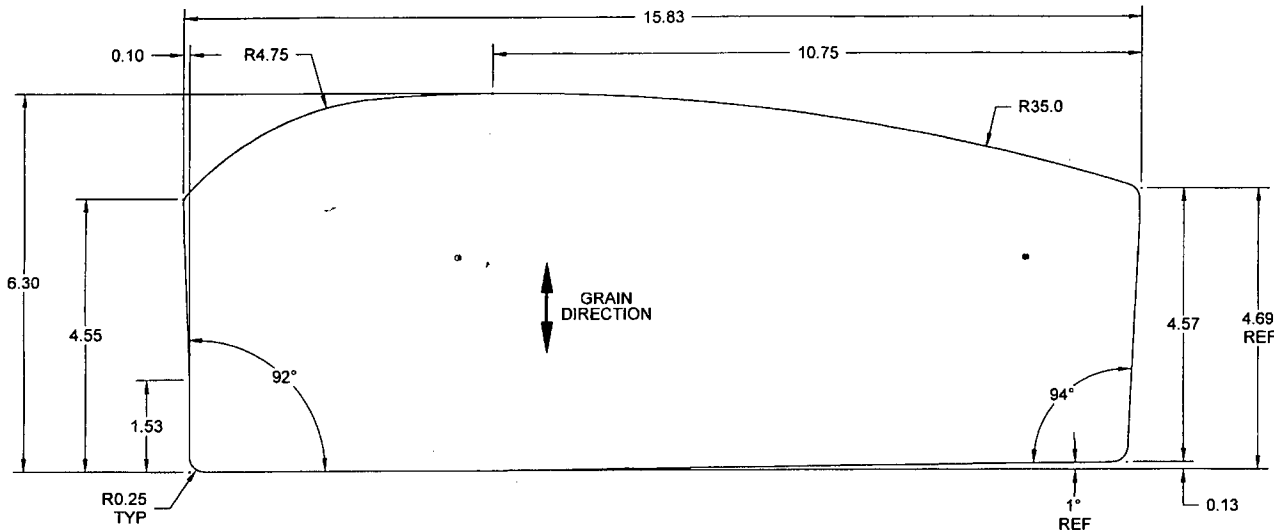
8 7 6 5 4 3 2 1

D

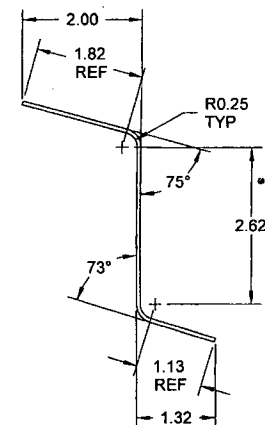
C

B

A



D3703-1F AFT DOUBLER FLAT PATTERN



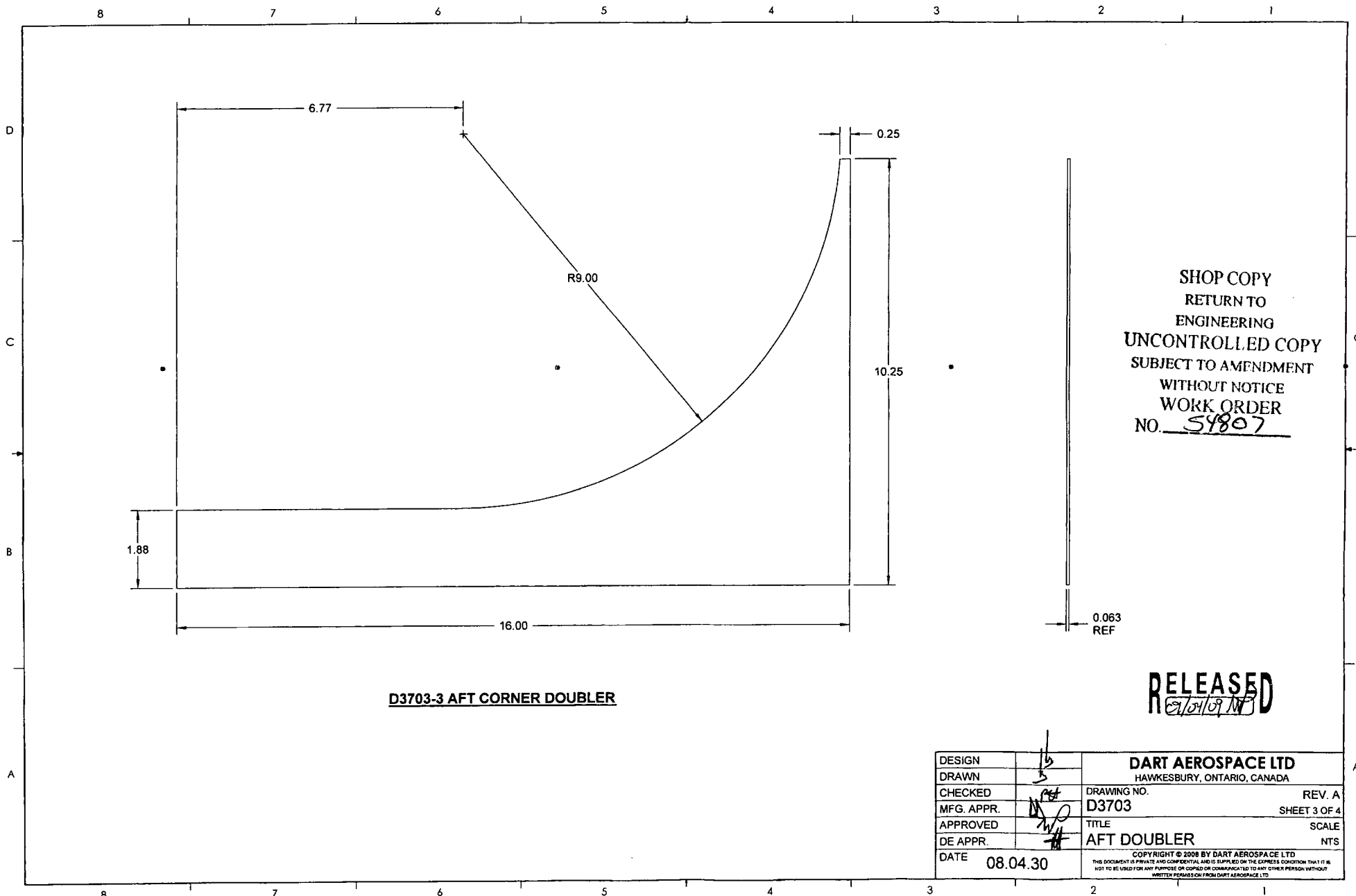
**D3703-1 AFT DOUBLER
(MAKE FROM D3703-1F)**

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NO. 34807

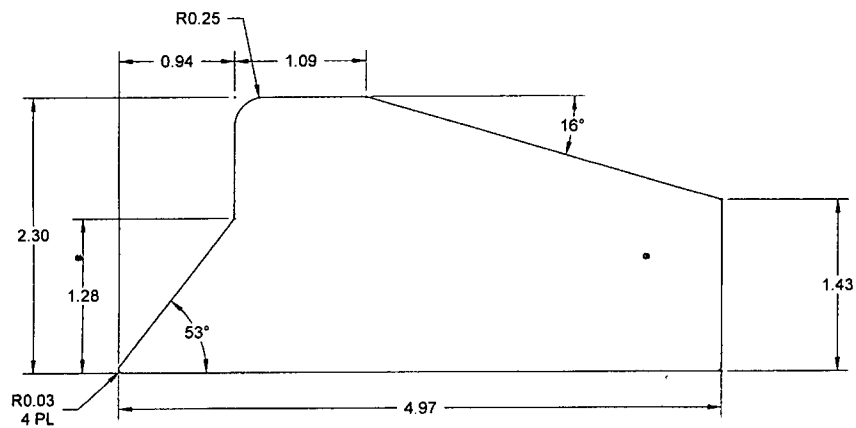
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D3703-5 AFT CAP

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